Work Orde Wednesday, June			·								Page 1
Revision ID: Item Name: (Start Date: (Required Date: (D3575-5 Cabin Floor Pro 6/2/2010 6/9/2010	otector Start Qty: 3.00 Req'd Qty: 3.00		Accept	Cust Item I				Setup St	1 188111	
	Process Plan	//	Date: 165 (Teoling: SPC (Y/N):		ate:		F			
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe	Insp. r Stamp
Draw Nbr	Revis	sion Nbr							~~~		
D3575	Rev A	A									
100 		FLOW WATER JET Memo 1-Cut as pe Deburr if no	r Dwg D3575 □Dwg Rev ecessary	0.00 0.00 :□Prog Rev:	<u>A</u>			Bic	o - 6	7	
110 QC Quality Control		QC2- Inspect parts off n Memo	nachine FAI/FAIB	0.00				UT31 C)-6 - 7		
120 QC Quality Control		QC8- Inspect parts - sec Memo	ond check	0.00	مو ا <i>ن</i>			_3	· ·		****

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	iES					*
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			,							
Part No	•	PAR #:	Fault Cat	egory:	_ NCF	R: Yes	No DQ	A:	Date:	
	Resolution:			on:	QA:					
NCR:		V	VORK ORE	DER NON-CONFORMA	ANCE	(NCR)			
DATE	STEP	Description of NC			ion B		Verific	ation	Approval	Approval
	O L	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
:										
<u> </u>										
					:					

Work Order ID 59364

Wednesday, June 02, 2010 1:17:41 PM



Page 2

Item ID:

D3575-5

Accept

Setup Start



Revision ID:

Item Name:

Cabin Floor Protector

Start Date:

6/2/2010

Start Qty: 3.00

Required Date: 6/9/2010

Req'd Qty: 3.00

Cust Item ID: Customer:

Tool ID

Reference:

Δ	pprovals	
_	μμιυναιδ	•

Process Plan: Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Run Start

Reject

Qty

Stop

Stop

Insp.

Stamp

Reject

Number

Sequence ID/

Work Center ID

130

Small Fab Small Fab

Operation Description

Small Fab

Memo

Memo

Deburr if necessary.

Set Up/ **Run Hours**

0.00

0.00

140

Quality Control

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location:

Accept

Oty

150

Packaging Packaging

Memo

0.00

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Part No: _		,	WC	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-										
Part No	•	PAR #:	Fault Cata	norw.	NCD	. Vaa 1	No. 00	<u></u>		
		solution:								
NCR:				ER NON-CONFORM						
DATE	STEP	Description of NC		Corrective Action Section B			Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
			:							
					-	_				
								·		

Work Order ID 59364 Wednesday, June 02, 2010 1:17:41 PM												The state of the s	Page 3
Item ID: Revision ID:	D3575-5				Accept					Setup		1	
Item Name:Cabin Floor ProtectorStart Date:6/2/2010Start Qty:3.00Required Date:6/9/2010Req'd Qty:3.00Reference:		? (8.6) 8. (19.6) 1. (18.6) 8. (19.6)			Cust Item ID: Customer:					Stop			
Approvals:	Process P	Plan:	Date:		Tooling: SPC (Y/N):		ate:			Run	Start Stop		
Sequence ID/ Work Center I	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
160 		QC21- Final Inspection	- Work Order Re	elease	0.00						/	10/00	0/09 /

Memo

Quality Control

10/06/09 A) N 10-6-08

	P									,
W/O:			WO	RK ORDER CHAN	GES				7.0	2 ,
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										·
Part No	:	PAR #:	Fault Categ	jory:	NCR:	Yes I	No DQ	 A:	Date:	
		olution:								
NCR:			WORK ORDE	R NON-CONFORM	IANCE (NCR)			
DATE	STEP	Description of NC		ction B	Cian 9 Ve			Approval	Approval	
	OIL!	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector

Picklist Print Page 1 Wednesday, June 02, 2010 1:17:45 PM Work Order ID: 59364 Parent Item: D3575-5 Parent Item Name: Cabin Floor Protector **Start Date:** 6/2/2010 Required Date: 6/9/2010 Comments: IPP Rev : A New Issue 07.07.23 verified by:JLM Start Qty: 3.00 Required Qty: 3.00 Component Item ID/ Replacement Mfg/ Primary Bin Last Unit of Route Qty on Qty per Kit Total Qty Date Status Item Name Item ID Purch Measure Item Location Location Seq ID Hand Qty Issued Issued MLEXS.125-F60029-04 Purchased No 100 sf 1,769.706 10.666 33.68211 B10-6-7 GE PLASTICS LEXAN SHEET

W/O:	•		W	ORK ORDER CHANG	iES					<u> </u>
DATE	STEP	PRC	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							·			
Part No	•	PAR #:	Fault Cate	gory:	_ NCF	l: Yes N	lo DQA		Date: _	
	R	esolution:							Date: _	
NCR:	-	\	NORK ORD	ER NON-CONFORM	ANCE	(NCR)		•		
DATE	STEP	Description of NC	l. iai a		ion B	0: 0	Verifica	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sectio	n C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	39364
Description: Cabin Floor Protector	Part Number:	D3575-5
Inspection Dwg: D3575 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension			Inspection	
Ø3.00	+0.006/-0.001	3,003	4			,
3.38	+/-0.030	3,38	* >			
6.50	+/-0.030	6,50	1	-		
26.13	+/-0.030	24.13	6			
30.13	+/-0.030	30,13	7			
2.00	+/-0.030	2,00	100			
3.50	+/-0.030	3.50	*			
14.25	+/-0.030	14.75	*	-		
25.13	+/-0.030	25,13	6			
29.38	+/-0.030	29,38	8	-		
30.38	+/-0.030	30.38	V			
31.50	+/-0.030		r			
1.00	+/-0.030	1,00	€ .			
4.38	+/-0.030	4.30	6			
14.50	+/-0.030	14.50	7			
16.00	+/-0.030	16.20	-	-		
23.13	+/-0.030	23,13	2			
26.88	+/-0.030	88.26	Y			
27.69	+/-0.030	27.69	85			
1.00	+/-0.030	1,00	2			
3.75	+/-0.030	3,75	8			
9.63	+/-0.030	9.63	>			
16.13	+/-0.030	16.13	7			
28.06	+/-0.030	28.06	1			
32.15	+/-0.030	39.0	4	-		

Measured by:	限	Audited by:	5,	Prototype Approval:	N/A
Date:	10-6-7	Date:	10/66/07	Date:	N/A

Rev	Date	Change	Revised	by,	Approved
Α	08.01.16	New Issue	KJ//DD	ox I	13/
				- ()	

	•											
W/O: .		WORK ORDER CHANGES										
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					-				-			
Part No		PAR #:										
Res		esolution:	tion: Disposition:			QA: N/C Closed: Date: _						
NCR:		·	WORK ORD	ER NON-CONFORM	ANCE	(NCR)						
DATE	STEP	Description of NC	Corrective Action Section B			Varitio			Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector		
	,											
<u></u>					-							

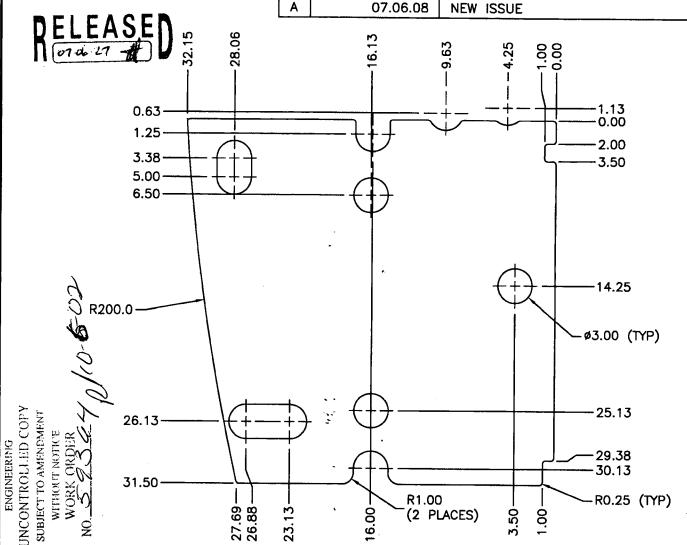


DESIGN DRAWN BY DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

CHECKED APPROVED DRAWING NO.
D3575 SHEET 1 OF 4

TITLE SCALE

O7.06.08 CABIN FLOOR PROTECTOR 1:8



D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

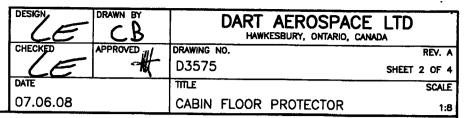
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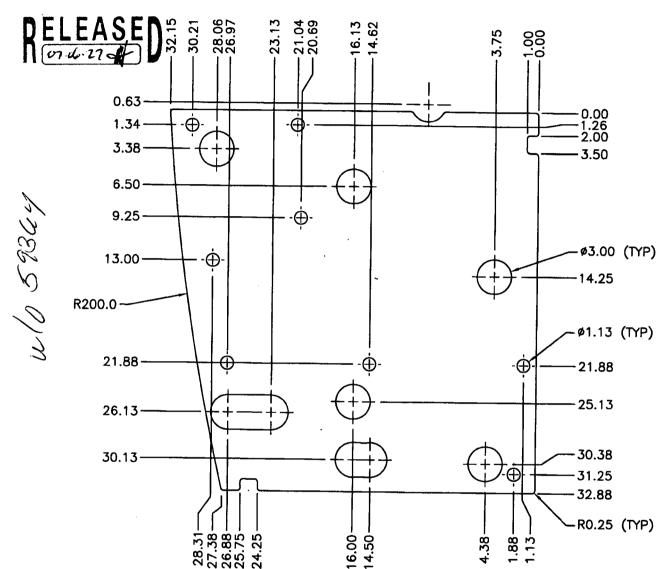
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W/O:			WC	RK ORDER CHANG	GES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		PAR #:								
NCR:	nes	solution:		II:ER NON-CONFORM					Date:	
			Corrective Action Section B			R				
DATE	STEP	P Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Verification Section C		Approval Chief Eng	Approval QC Inspector
					h:					
									:	
					•					







D3575-3 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

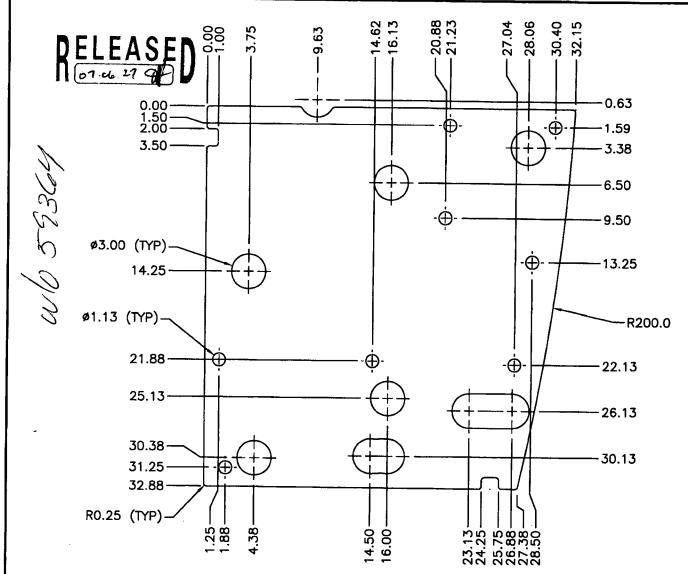
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W/O:			WC	RK ORDER CHANG	GES				*		
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			Fault Category: NCR: Yes No DQA:								
		esolution:				Date: _	ate:				
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NO	R)					
DATE	STEP	Description of NC	Corrective Action Section B			Verifi	cation	Approval	Approval		
	Section A	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ion C	Chief Eng	QC Inspector		



DESIG	E	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAR	
CHEC	KED	APPROVED	DRAWING NO.	REV. A SHEET 3 OF 4
DATE			TITLE	SCALE
07.	06.08		CABIN FLOOR PROTECTOR	1:8



D3575-4 CABIN FLOOR PROTECTOR

NOTES:

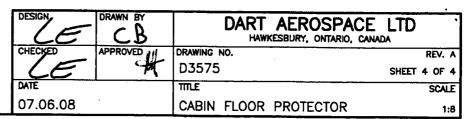
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

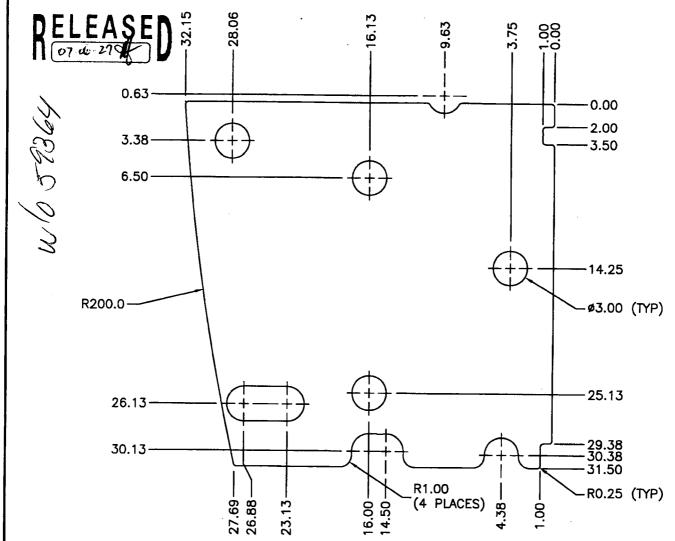
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W/O:			WC	RK ORDER CHANG	ES	<u></u>			
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				-					
Part No:		PAR #:	Fault Cate	NCR: Ye	Date: _):			
		esolution:					Date:		
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NO	R)		1,11,11,11,11,11,11,11,11,11,11,11,11,1	
DATE	STEP	Description of NC Section A	Corrective Action Section E			Veri	fication	Approval	Approval
-			Initial Chief Eng	Action Description Chief Eng	Sigi Da	te Se	ction C	Chief Eng	QC Inspector
	,								
								:	<u>.</u>
•									







D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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W/O:			WC	ORK ORDER CHANG	ES				t 4
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								<u> </u>	
Part No		PAR #:							
	R	esolution:	Disposition:			QA: N/C Closed:			
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCI	7)			
DATE	STEP	Description of NC	Corrective Action Section B			Veritic		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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